

Work Order ID 114818

March-13-14 11:47:27 AM

114818

Page 1

Item ID: D3719-041

Revision ID:

Item Name: Wearplate

Start Date: 3/13/14

Required Date: 3/20/14

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3719

Rev A

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3719

Dwg Rev: A

Prog Rev: A 2-

Deburr if necessary

14 EL 14-3-14

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

14 EL 14-3-14

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

14

DAS
27
9-89

14/3/17



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Page 3

Item ID: D3719-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate
Start Date: 3/13/14 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 3/20/14 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M125028</i>	0.00				9	0	14-8-25	DAS 34 9-89
	Memo START TIME: <i>1:20</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>1:50</i>	0.00							
170 *170* QC Quality Control	QC3- Inspect Part Finish	0.00				9	0	(2P) 14/03/25	
	Memo	0.00							
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>57000</i>	0.00						14/3/27 (9)	DAS 32 9-89
	Memo	0.00							

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Item ID: D3719-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 3/13/14

Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/20/14

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

PL 14-03-31

MCS 14-03-27



Picklist Print

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Parent Item: D3719-041

D3719-041

Parent Item Name: Wearplate

Start Date: 3/13/14

Required Date: 3/20/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev :A New Issue 07-12-19 EC verified by DD
IPP Rev:B 08-09-25 add QC5 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3009-3		Manufactured	No			100	Each	152.0000	4	20			
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D3009-3

Cup

Location

Loc Qty

Loc Code

WA001

152

103891

32

108451 **x 44**

60

109092 **x 12**

60

M304S16GA		Purchased	No			130	sf	309.9370	0.565	3			
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No

130

sf

309.9370

0.565

3

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

309.937

M126915

1.487

M127821

126.13

M128054

54.32

M128423

128

X56 14-03-18 MAL

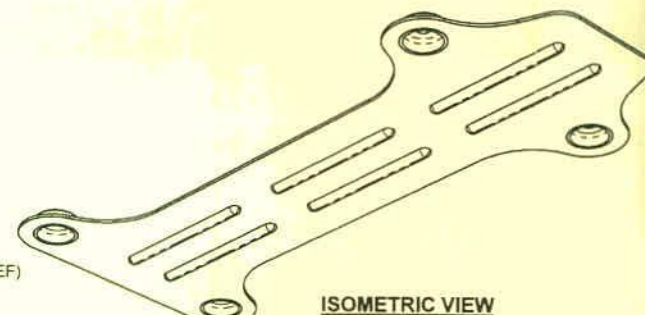
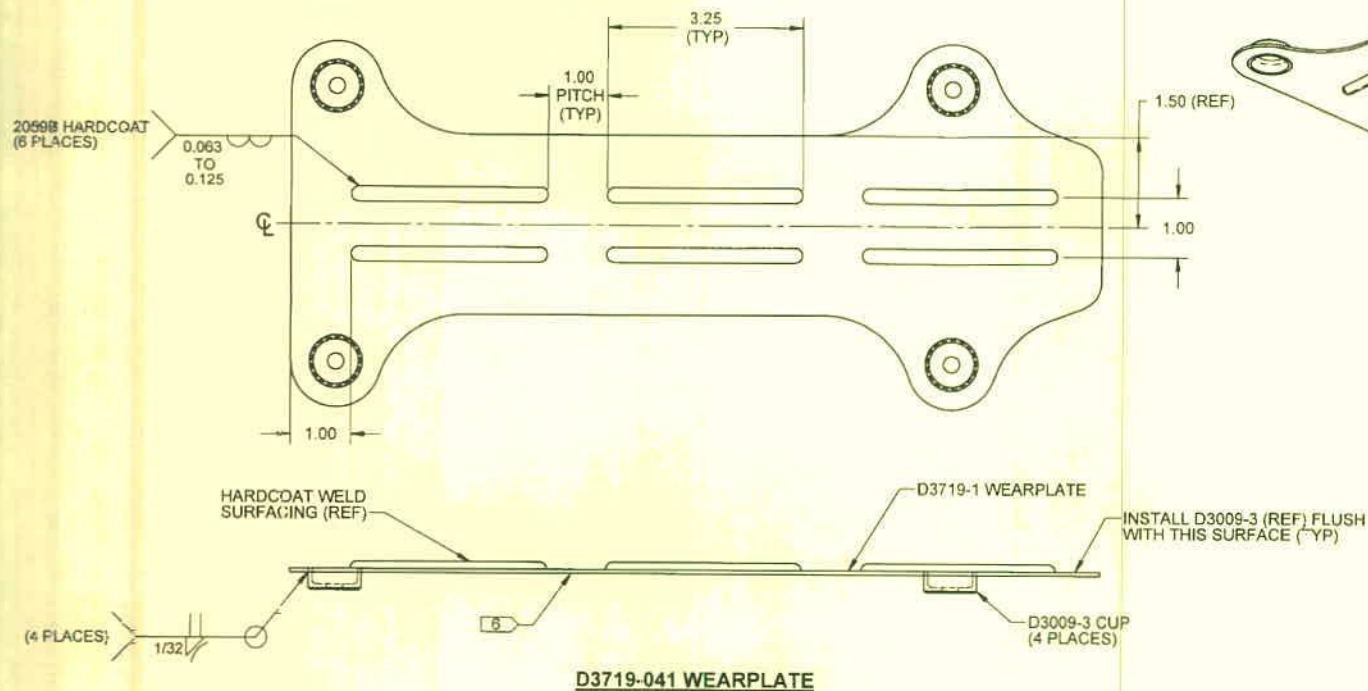
EC 14-3-14

9.33



114518

PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE
 - 9) WELD PER DART QSI 004

RELEASED
05-01-07

A NEW ISSUE		CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	93		
DRAWN	93		
CHECKED	93		
MFG. APPR.	93		
APPROVED	93		
DE APPR.	93		
DATE	07.12.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3719** REV. A
SHEET 1 OF 2
TITLE **WEARPLATE** SCALE 1:2

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